

Date: Monday, 11/21/2005 1:17:15 PM
 User: Linda Lacelle

(16)

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE		
Job Number	: 24855		Part Number	: D29331		
Estimate Number	: 10833		Drawing Number	: D2933 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/21/2005	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/21/2005 Qty: 4 Um: Each		
Previous Run	: N/A					
Written By	<u>SEE COMMENT BELOW</u>					
Checked & Approved By	<u>SEE ABOVE USER & DATE</u>					
Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:

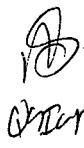
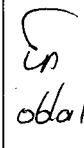
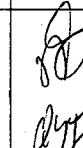


Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <u>B24890</u> Er 06/01/14 4.
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. Er 06/01/14 1-Inspect part number and batch number are programmed correctly. J.G. 06/01/14 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr Er 06/01/15 3/20 06/01/15 4 PTO
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet SD 06.04.13 4
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET SD 06.04.13 4

Oval

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/01/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/01/15  2.3		one Part scrap - Part must have 1.675" Drum making 0.220" causing flange thickness (0.220" to be 0.20") to thin.	 GMBR	Scrap and Design and Replace. Re check all origins.	 06/01/15	 06/01/15	 06/01/15	 06/01/15

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ML 06/04/18 4

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-04-18 4

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-04-18

4

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 06/04/18 4

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SB 06/04/18 4

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10 06/04/18 4

Job Completion



10 06/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	
Description: 206 Saddle, Inboard, Left side				Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.118	0.120	0.121	0.119		
B	0.100	0.140		0.119	0.120	0.120	0.117		
C	0.100	0.140		0.123	0.122	0.121	0.120		
D	0.210	0.230		0.215	0.217	0.217	0.215		
E	1.245	1.255		1.248	1.247	1.247	1.248		
F	1.245	1.255		1.248	1.247	1.247	1.248		
G	2.495	2.505		2.488	2.488	2.496	2.497		
H	0.510	0.515		.515	.515	.515	.515		
I	1.572	1.582		1.577	1.577	1.576	1.576		
J	2.495	2.505		2.499	2.499	2.499	2.497		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.122	0.122	0.124	0.120		
O	0.540	0.560		0.547	0.545	0.547	0.548		
P	0.490	0.510		0.503	0.500	0.501	0.501		
Q	3.715	3.725		3.717	3.718	3.718	3.718		
R	2.470	2.510		2.500	2.500	2.498	2.501		
S	0.240	0.270		0.248	0.248	0.247	0.247		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.629	1.628	1.628	1.631		
V	1.362	1.372		1.367	1.367	1.366	1.367		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.136	1.137	1.134	1.133		
Y	1.565	1.585	DT8695 A/B	—	—	—	—		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SP</i> / SD	Audited by:	<i>JMB</i>
Date:	06/04/13	Date:	06/10/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No : 0024855
Project Name : D2933-1
Project For : WK551
Work Order Type : Main
Main WO Number :
House Part Number : D2933-1
Description : 206 Saddle Left
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 11-17-05
Est Finish Date : 12-21-05
Act Finish Date :
Drawings Reqd : No
Ok for Approval :
Approval Rec'd :
Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00